

Work Order ID 70258 -1

Thursday, June 02, 2011 9:18:27 AM

Page 1

Item ID: D4054-009

Revision ID:

Item Name: Tube Assembly

Start Date: 6/2/2011 Start Qty: 4.00

Required Date: 6/3/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date: 11-06-07

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4054

A

100

0.00

2



Small Fab

Small Fab

Memo

0.00

Small Fab

Bend tube as per Dwg D4054

Install sleeves and nuts

Flare ends as per Dwg D4054

SD 11/06/07

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sub 662

+2

Quality Control

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Item ID: ID4054-009

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 6/2/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

120

Identify as per dwg & Stock Location

193

0.00



Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

Handwritten signature and date 6/2/11

Handwritten date 6/3/11 and initials MF

Picklist Print

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Page 1

Work Order ID: 70258

Parent Item: D4054-009

Parent Item Name: Tube Assembly



Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.01.19 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN818-8D Purchased No



Nut

Location

Loc Qty

Loc Code

ST331

10

115594

5

117514

5

M6061T6T0.500W.049 Purchased No



6061-T6 RD Tube 500 x 049W

Location

Loc Qty

Loc Code

MAT014

329.667

117270

329.667

MS20819-8D Purchased No



Sleeve

Location

Loc Qty

Loc Code

ST323

32

114544

32

10.0000

1

4



SA 11/06/02

329.6670

0.55

2.315789



SA 11/06/02

32.0000

1

4



SA 11/06/02

SA 11/06/02

2

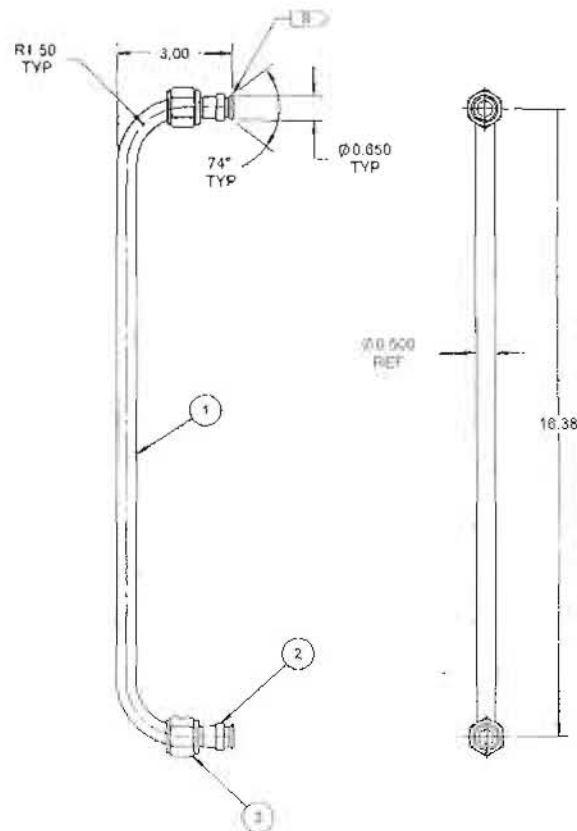
SA 11/06/02

M111944 : 2.315789

SA 11/06/02

2

ITEM NO.	QTY	PIN	DESCRIPTION
1	X	D4054-001	TUBE ASSEMBLY
2	2	MS30519-80	SLEEVE
3	2	AN516-80	NUT



D4054-001 TUBE ASSEMBLY

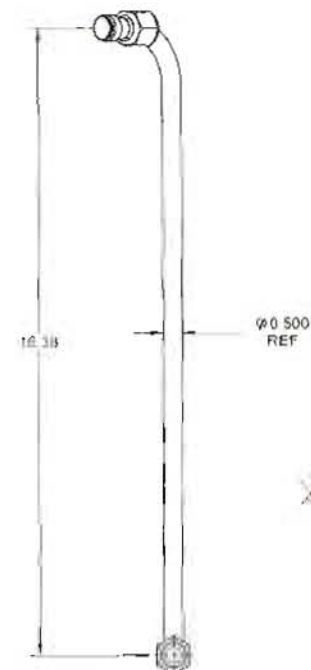
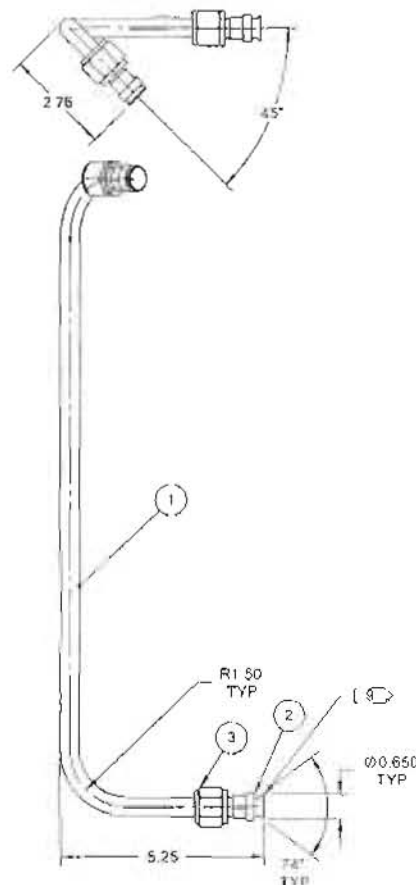
NOTES:

- 1) MATERIAL: 6061 T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W 049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK: SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-001" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.20 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-001T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14
MD

REV	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	RF	DRAWING NO. D4054		REV. A
MFG APPR.	RF			SHEET 1 OF 3
APPROVED	RF	TITLE TUBE ASSEMBLIES		SCALE
DATE	09.12.30			NPS

ITEM	QTY	P/N	DESCRIPTION
1	X	D4054-003	TUBE ASSEMBLY
2	2	MS20816-80	SLEEVE
3	2	AN818-80	NUT



NOTES

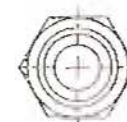
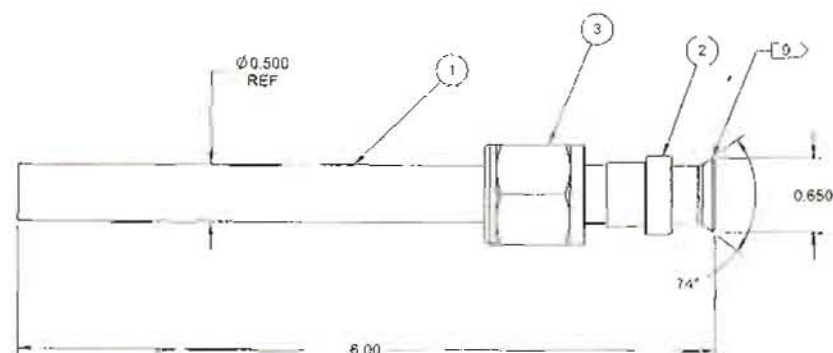
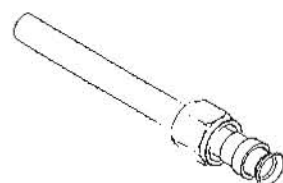
- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-1-700/R
REF DART SPEC M6061T6D 500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-003" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.21 LBS
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE (D4054-003T)
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS32514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

D4054-003 TUBE ASSEMBLY

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	MILWAUKEE, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV A
MFG APPR	RF	D4054	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DATE	09 12 30	TUBE ASSEMBLIES	NTS

RELEASED
2010-01-14
MP

ITEM	QTY	P/N	DESCRIPTION
1	X	D4054-009	TUBE ASSEMBLY
2	1	MS33514-02	SLEEVE
3	1	AN6-18-ED	NUT



Handwritten: X 70258

D4054-009 TUBE ASSEMBLY

NOTES

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.019 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W 049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSR 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES. 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-009" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-009T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14
Handwritten signature

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	MISSISSAUGA, ONTARIO, CANADA
CHECKED	<i>Handwritten signature</i>	DRAWING NO. D4054 REV. A
MFG APPR	<i>Handwritten signature</i>	SHEET 3 OF 3
APPROVED	<i>Handwritten signature</i>	TITLE TUBE ASSEMBLIES SCALE NTS
DATE	09 12 30	COPYRIGHT © 2009 BY DART AEROSPACE LTD